



Dart Aerospace Ltd.
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D135-1027-103
Job Sheet 198955



Part No: D135-1027-103

Job Qty: 1 pcs ✓

Part Name: H135/EC135 - FWD Crosstube - Mid Height - w/ Saddles



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/8/19

Job Tracking No:

Due Date: 8/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D135-1027 REV.D IPP REV:A 17.10.24 NEW ISSUE DD VERF:JFS IPP REV:B 18.11.08 AS PER IIN
REV.C DD VERF:JFS IPP REV:C 19.04.22 AS PER IIN REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		8/22/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		Oscar
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Container No: S204161



Part: D135-1027-103

Job No: 198955

Serial No/Batch: S204161

Revision: D

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue Date 18/11/21, EA

Master Unit
No 011304

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
110 QC 4	1 pcs	8/22/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
130 Packaging 3-1 - Stock - B4B	1 pcs	8/22/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	8/22/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	8/22/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 100 - Packaging1-1 (Pick Kit)
 Descriptions: 110 - QC4 (QC4- 100% Inspect kits for completeness)
 130 - Package as per PPP D135-1027-103 Identify and Stock Location :

135 - (Document Control) Photocopy blue file & type labels as per PPP D135-1027-103 CHG 001

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	4 Ea (4 ea) ✓	100-Packaging 1 - Pick Kit	S167426 ✓
D135-1027-143	H135/EC135 - FWD Crosstube - Mid Height	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	S167426 S1911 12
D5416-1	Bushing	4 pcs (4 ea) ✓	100-Packaging 1 - Pick Kit	S032829 ✓
D5417-1	Support Plate	4 pcs (4 ea) ✓	100-Packaging 1 - Pick Kit	S036072 ✓
D5464-1	Washer	4 pcs (4 ea) ✓	100-Packaging 1 - Pick Kit	S033379 ✓
D5720-041	Saddle Clamp	4 pcs (4 ea) ✓	100-Packaging 1 - Pick Kit	S198662 ✓
MS21042-5	Nut <i>51304</i>	2 Ea (2 ea) ✓	100-Packaging 1 - Pick Kit	S180182 ✓
MS21043-3	Nut	8 Ea (8 ea) ✓	100-Packaging 1 - Pick Kit	S176493 ✓
MS24665-306	Cotter Pin	8 Ea (8 ea) ✓	100-Packaging 1 - Pick Kit	F4137878.70 ✓
NAS1149C0363R	Washer (AN960C10)	8 Ea (8 ea) ✓	100-Packaging 1 - Pick Kit	S181423 ✓
NAS1149D0563J	Washer	8 Ea (8 ea) ✓	100-Packaging 1 - Pick Kit	S134692 ✓
AN5-44A	Bolt	2 Ea (2 ea) ✓	100-Packaging 1 - Pick Kit	S072696 ✓
D5415-1	Med Height Saddle	2 pcs (2 ea) ✓	100-Packaging 1 - Pick Kit	S199058 ✓
D5677-1	Pin	2 pcs (2 ea) ✓	100-Packaging 1 - Pick Kit	S159900 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	AN310C8	4	61	0
	AN5-44A	2	61	0
	D135-1027-143	1	5	0
	D5415-1	2	19	0
	D5416-1	4	24	0
	D5417-1	4	25	0
	D5464-1	4	16	0
	D5677-1	2	8	0
	D5720-041	4	12	0
	MS21042-5	2	0	0
	MS21043-3	8	803	0
	MS24665-306	8	46	0
	NAS1149C0363R	8	638	0
	NAS1149D0563J	8	1,981	0

Part Specifications

Specifications could not be found.

Plex 8/8/19 11:00 AM Dart.lajeunesse.marie

Master Unit No

011304

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			

32.9 PARTS LIST

For convenience, only the last three digits of the part number are listed on the top row of the table. The quantity of each component which is included in the D135-1027-101 Kit, for example, is as defined in the column labeled -101.

Qty -101	Qty -103	Qty -201	Qty -203	Part Number	Description
X				D135-1027-101	STD HEIGHT FWD CROSSTUBE INSTALLATION
	X			D135-1027-103	MID HEIGHT FWD CROSSTUBE INSTALLATION
		X		D135-1027-201	STD HEIGHT AFT CROSSTUBE INSTALLATION
			X	D135-1027-203	MID HEIGHT AFT CROSSTUBE INSTALLATION
1				D135-1027-141	STD HEIGHT FWD CROSSTUBE ASSY
	1			D135-1027-143	MID HEIGHT FWD CROSSTUBE ASSY
		1		D135-1027-241	STD HEIGHT AFT CROSSTUBE ASSY
			1	D135-1027-243	MID HEIGHT AFT CROSSTUBE ASSY
2	2	2	2	D5411-1 (1)	RUBBER BUSHING
2	2	2	2	D5412-041 (1)	CROSSTUBE CLAMP
2	2	2	2	D5413-1 (1)	CROSSTUBE SUPPORT
4	4	4	4	D5414-1 (1)	SUPPORT BOLT
	2		2	D5415-1	MID HEIGHT SADDLE
2		2		D5415-3	STANDARD HEIGHT SADDLE
4	4	4	4	D5416-1	BUSHING
4	4	4	4	D5417-1	SUPPORT PLATE
4	4	4	4	D5464-1	WASHER
		2	2	D5541-041	GROUND HANDLING PIN
		2	2	D5541-3	GROUND HANDLING NUT
			4	D5541-5	GROUND HANDLING WASHER
2	2			D5677-1	PIN
4	4	4	4	D5720-041	CLAMP
4	4	4	4	AN310C8	NUT, CASTELLATED
2	2	2	2	AN5-44A	BOLT
2	2	2	2	MS21042-5	NUT, SELF LOCKING
8*	8*	12*	12*	MS21043-3	NUT, SELF LOCKING
8	8	8	8	MS21043-5 (2)	NUT, SELF LOCKING
8*	8*	8*	8*	MS24665-306	COTTER PIN
8*	8*	12*	12*	NAS1149C0363R	WASHER
8	8	8	8	NAS1149C0532R(2)	WASHER
8*	8*	8*	8*	NAS1149D0563J	WASHER
8	8	8	8	NAS1802-5-26(2)	BOLT, CRES

* Additional hardware provided.

(1) Pre-assembled on D135-1027-141/-143/-241/-243 Crosstube Assemblies.

(2) Pre-assembled on D5720-041 Clamp.

Change Record

PAGE 1 OF 1

Part Number: D135-1027-103

Description: MID HEIGHT FWD CROSSTUBE INSTALLATION

[illegible]